

# Work Order ID 80290

**\*80290\***

Page 1

February-16-12 10:28:28 AM

Item ID: D3391-021 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Fwd Tube Assembly  
 Start Date: 16/02/2012 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 01/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: M.L.J Date: 12/02/16 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3391	1

100	Skidtubes	0.00							
<b>*100*</b>									
Skidtubes	Memo	0.00							
Skidtubes	Cut extrusion to 46.52 +0.010 -0.020								

*DL 12/03/01*

110	BENDING MACHINE - SKIDTUBES	0.00							
<b>*110*</b>									
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D3391 Using Bend Prog 3391021								

*LD 12-3-1*

120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									

*6.750* *BE* *12/03/01*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80290

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Item ID: D3391-021

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
<b>*130*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	<b>Memo</b>	0.00							
HAAS CNC vertical machine #1	1-Machine as per Folio FA590 Rev. <u>14</u> & Dwg D3391 Rev. <u>I</u> <u>onk 12/03/05</u>								
	Identify as D3391-1								
	2-Deburr								
140		0.00							
<b>*140*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00							
Quality Control									
150		0.00							
<b>*150*</b>	CONVENTIONAL MILLING MACHINE								
Mill Conv	<b>Memo</b>	0.00							
Conventional Milling Machine	Drill X1 Aft cap as per Dwg D3391 .1875" dia								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\* 1 \***

**Cust Item ID:**

**\* 1 \***

**Customer:**

**Reference:**

Run Start \*NR1\*

**Approvals:** \_\_\_\_\_ **Process Plan:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **Tooling:** \_\_\_\_\_ **Date:** \_\_\_\_\_

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

# Insp. Stamp

0.00

**\*160\***

QC

## Memo

0.00

## Quality Control

170

QC8- Inspect parts - second check

0.00

**\*170\***

QC

## Memo

0.00

## Quality Control

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
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Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Skidtubes	0.00							
<b>*180*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step								
	2-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size) (ONLY DRILL HOLES MARKED "A")								
	3-Open tow cap holes to .208" as per Dwg D3391								
	4-Open Tow Ring hole to .640" as per Dwg D3391								
	5- open float bag holes 0.328" and counter sink as per dwg D3391								
	6-Deburr & Scribe Batch number Inside aft end.								
	7-Transfer drill D3391-021 with D3391-023 ***NO WEARPLATE HOLES ARE TRANSFER DRILLED***								
190	QC5- Inspect part completeness to step on W/O	0.00							
<b>*190*</b>									
QC	Memo	0.00							
Quality Control									

1 Ø CF 12-3-7

DD 12-3-19

12-03-19 B

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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 Required Date: 01/03/2012 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*200*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
210	QC3- Inspect Part Finish	0.00							
<b>*210*</b>									
QC	Memo	0.00							
Quality Control									
220	Skidtubes	0.00							
<b>*220*</b>									
Skidtubes	Memo	0.00							
Skidtubes	1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: M120666 exp. date: 13/01/30 cure time 12hrs. as per QSI015 2- grind crossbolt flush 3-back drill crossbolt if necessary								

HG - 12-3-19  
 / DC 12/03/20

DP 12-3-20

DC 12/03/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Item ID: D3391-021

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Fwd Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

QC5- Inspect part completeness to step on W/O

0.00

**\*230\***

QC

Memo

0.00

Quality Control

235

Pressure Wash per QSI005 4.3

0.00

**\*235\***

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

240

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

**\*240\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

2:15  
320 °F  
2:45

1X M-F 12/03/30

1X M-F 12/03/30

M120222

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Work Order ID 80290

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February-16-12 10:28:28 AM

Item ID: D3391-021

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Fwd Tube Assembly

Start Date: 16/02/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 01/03/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

250

QC3- Inspect Part Finish

0.00

\*250\*

QC

Memo

0.00

Quality Control

1 4 ul 12/04/01

255

Skidtubes

0.00

\*255\*

Skidtubes

Memo

0.00

Skidtubes

\*\*\*\* install D3591-1 spacer as per DS19364 and wearplate as per DWG \*\*\*\*

1 4 ul 12/04/02

257

QC5- Inspect part completeness to step on W/O

0.00

\*257\*

QC

Memo

0.00

Quality Control

Sc264/02

1 4 ul 12/04/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 80290

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February-16-12 10:28:28 AM

Item ID: D3391-021 Accept: \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Fwd Tube Assembly  
 Start Date: 16/02/2012 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 01/03/2012 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Identify as per dwg & Stock Location: <u>W16</u>	0.00	D412-742-043	1381093		1	0	MLJ 12/04/02	
*260*									
Packaging	Memo	0.00							
Packaging									
280	QC21- Final Inspection - Work Order Release	0.00							
*280*									
QC	Memo	0.00						MLJ 12/04/02	
Quality Control									

12-04-2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

February-16-12 10:28:33 AM

Page 1

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Work Order ID: 80290

\*80290\*

Parent Item: D3391-021

\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A05.09.13New issue KJ/JLM  
 IPP B06.02.10Dwg rev.D ecn 773 EC  
 IPP C06.05.02Added inspections EC  
 IPP D 07.03.13 rev F dwg EC  
 IPP E 07.11.07 revG dwg ecn1053P EC verified by: DD  
 IPP Rev:f ECN 1056 07-11-12 DD verified by: EC  
 IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC  
 IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC  
 IPP Rev I 09.02.02 added hardware EC verified by: DD IPP Rev:J  
 11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4095-051		Manufactured	No			255	Each	15.0000	1	1			
*D4095-051*													
Wearpad Assembly													
** 1378821 (x1) ML 12/04/02													

Location	Loc Qty	Loc Code
FP001	15	
78821	15	

D6013-047		Manufactured	No			100	Each	127.0000	1	1			
*D6013-047*													
Skidtube Material													
** 12 12/03/01													

Location	Loc Qty	Loc Code
LG	127	
72505	127	

D3670-4-200		Manufactured	No			220	Each	99.0000	4	4			
*D3670-4-200*													
SPACER													
** 12 12/03/20													

Location	Loc Qty	Loc Code
LG001	99	
72851	7	
77500	32	
78606	60	

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID: 80290

\*80290\*

Parent Item: D3391-021

\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3401-041 Manufactured No

255 Each 7.0000 1 1

\*D3401-041\*

Tow Cap Assembly

\*\*

1378990 (x1) JH 12/04/02

## Location

## Loc Qty

## Loc Code

FP002

7

76211

7

AN960C10L NAS1149C0332 Purchased No

255 Each 0.0000 10 10

\*AN960C10I\*

washer

X

\*\*

1118354 (x10) JH 12/04/02

AN3C4A Purchased No

255 Each 3,439.000 10 10

\*AN3C4A\*

BOLT

\*\*

JH 12/04/02

## Location

## Loc Qty

## Loc Code

ST350

3439

117313

2

117688

5

117872

10

118112

16

118451

2

119749

10

120187

2000

120423

394

120521

1000

X10

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Parent Item: D3391-021

\*D3391-021\*

Parent Item Name: Fwd Tube Assembly

Start Date: 16/02/2012

Required Date: 01/03/2012

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

255

Each

924.0000

4

4

\*D3672-1\*

Phenolic Washer

\*\*

Jul 12/02/12

## Location

## Loc Qty

## Loc Code

FP001

288

66821

288

ST060

636

72229

136

76277

500

AEIS-1032-225

Purchased

No

255

Each

0.0000

10

10

\*AFI S-1032-225\*

INSERT

A654-1032-225

X

\*\*

11/20/11 (x10) Jul 12/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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## FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	
E	09.12.14	Dwg Rev updated	KJ	
F	11.06.21	Dimension 0.500 added	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

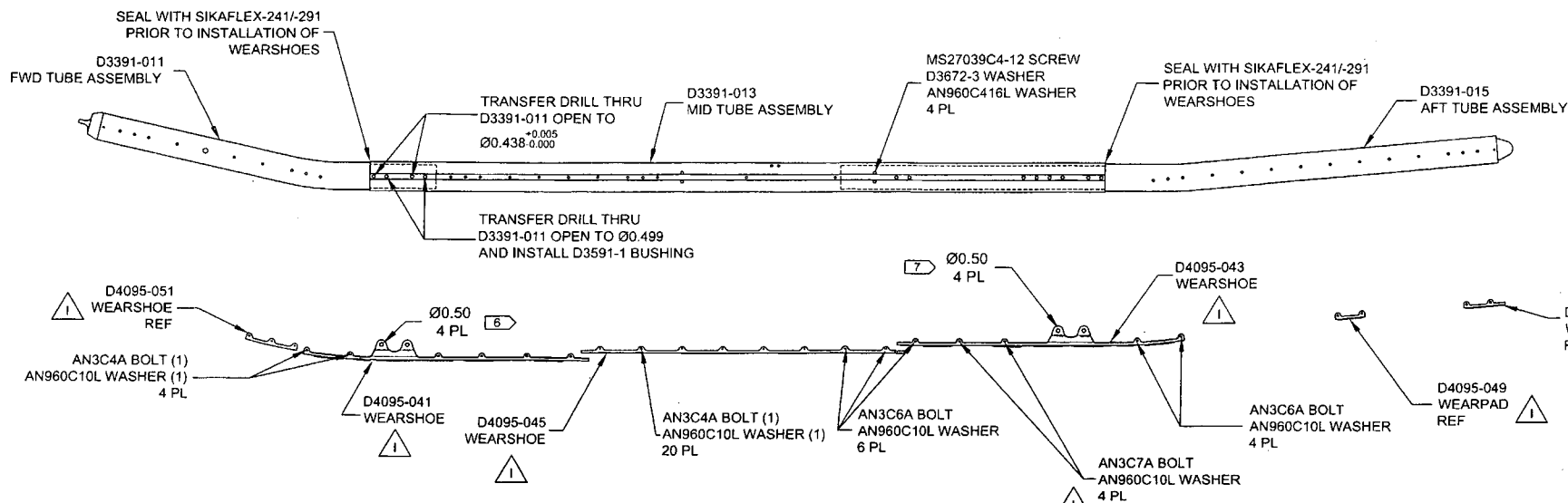
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
2	D3591-1	BUSHING
4	D3672-3	WASHER
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARPAD
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

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**GENERAL NOTES**

- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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2011-11-04  
ECN# 11-662

I	REMOVE GASKETS AND REPLACE ALL WEARSHOES; PARTS LIST UPDATE, ZN A8-1, ZN A8-2, ZN A8-4, ZN B6-8, LPS-3 COATING REMOVED FROM NOTE 2, ZN A3-1, ZN A3-2, REMOVED INSERT AELS-1032-130, ZN B6-4, B2-4, C7-8, C3-8; REMOVED HOLES, ZN D6-4 ZN D2-4, ZN D7-8, ZN D3-8	XDF	11.10.13
H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 Ø0.438 DIM WAS 4 PL. ADDED Ø0.499 DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
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MFG. APPR.		D3391	SHEET 1 OF 8
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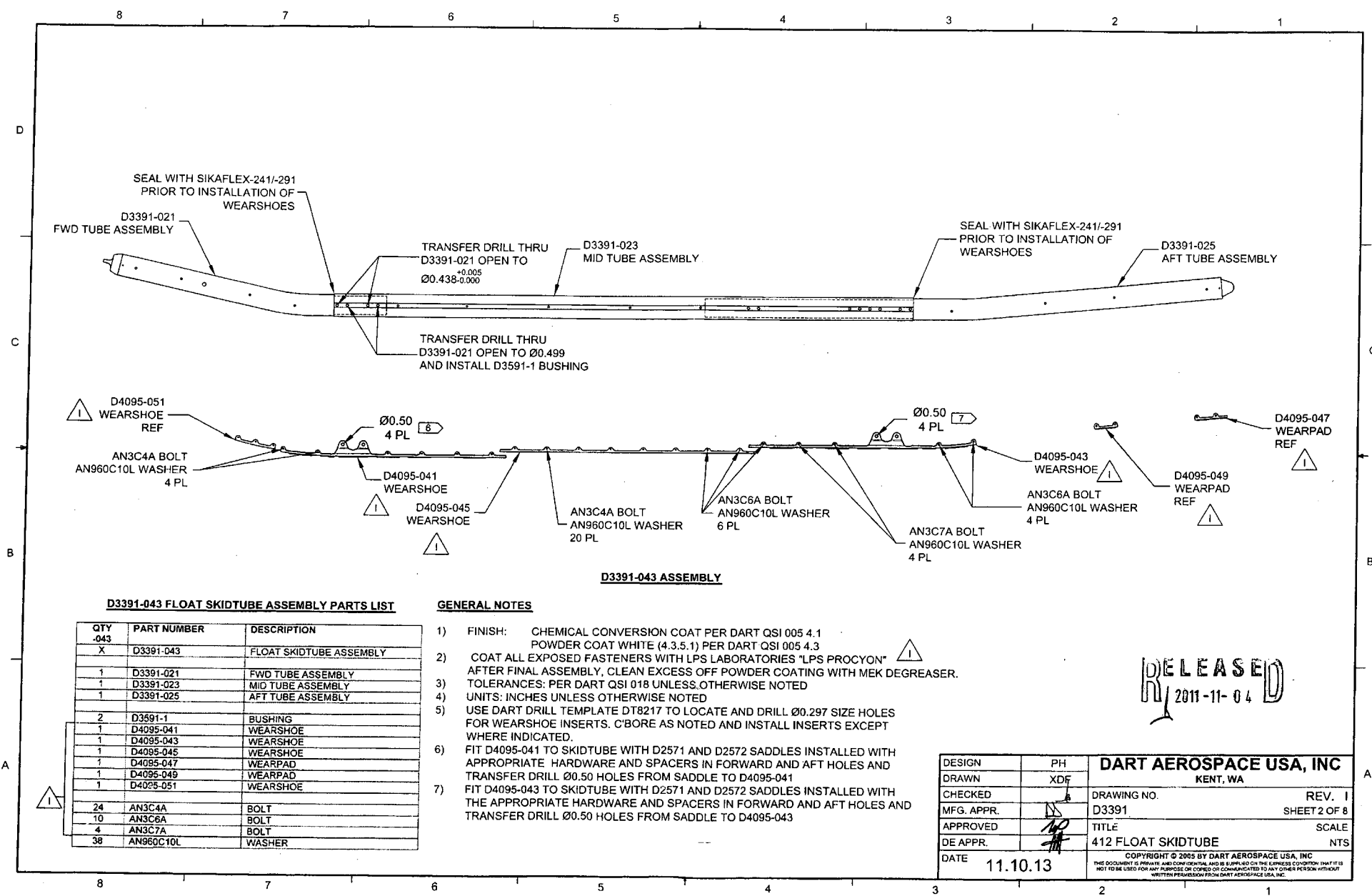
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**D3391-043 ASSEMBLY**

**D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
2	D3391-1	BUSHING
1	D4095-041	WEARSHOE
1	D4095-043	WEARSHOE
1	D4095-045	WEARSHOE
1	D4095-047	WEARSHOE
1	D4095-049	WEARSHOE
1	D4095-051	WEARSHOE
24	AN3C4A	BOLT
10	AN3C6A	BOLT
4	AN3C7A	BOLT
38	AN960C10L	WASHER

**GENERAL NOTES**

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON"
- 3) AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.
- 7) FIT D4095-041 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-041
- 8) FIT D4095-043 TO SKIDTUBE WITH D2571 AND D2572 SADDLES INSTALLED WITH THE APPROPRIATE HARDWARE AND SPACERS IN FORWARD AND AFT HOLES AND TRANSFER DRILL Ø0.50 HOLES FROM SADDLE TO D4095-043

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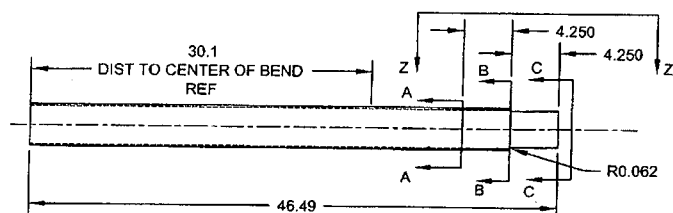
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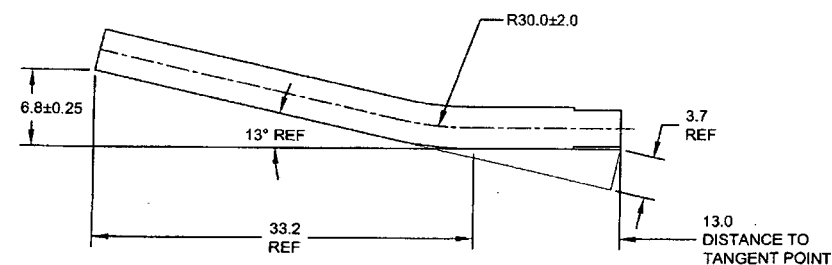
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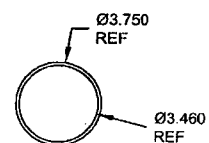
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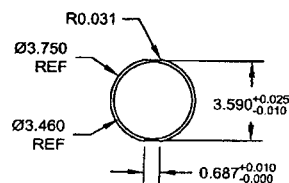
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



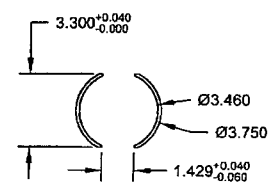
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



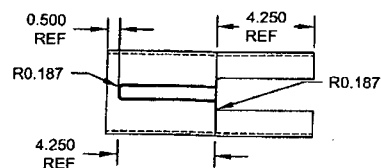
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SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



**VIEW Z-Z**  
SCALE 2X

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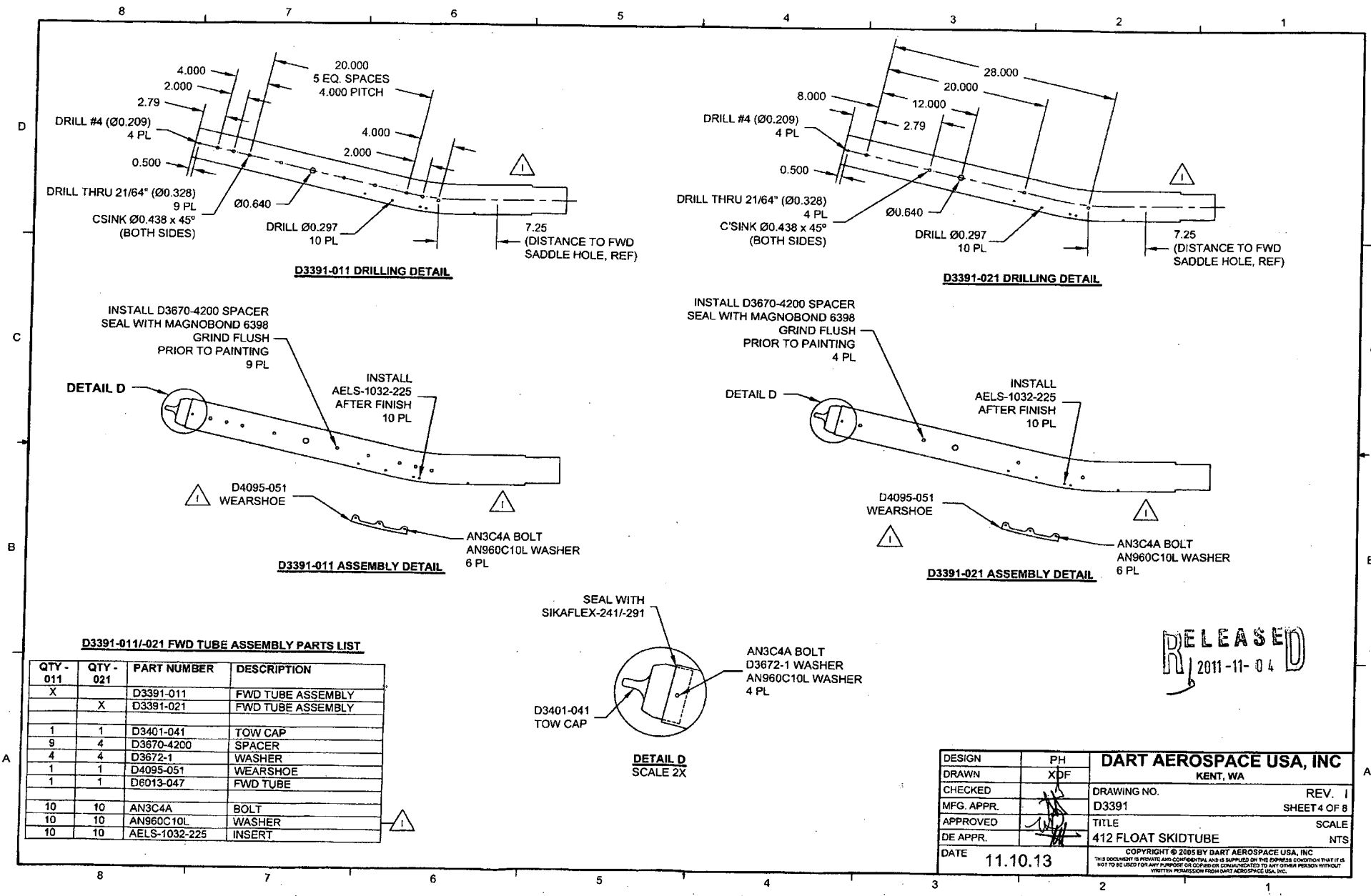
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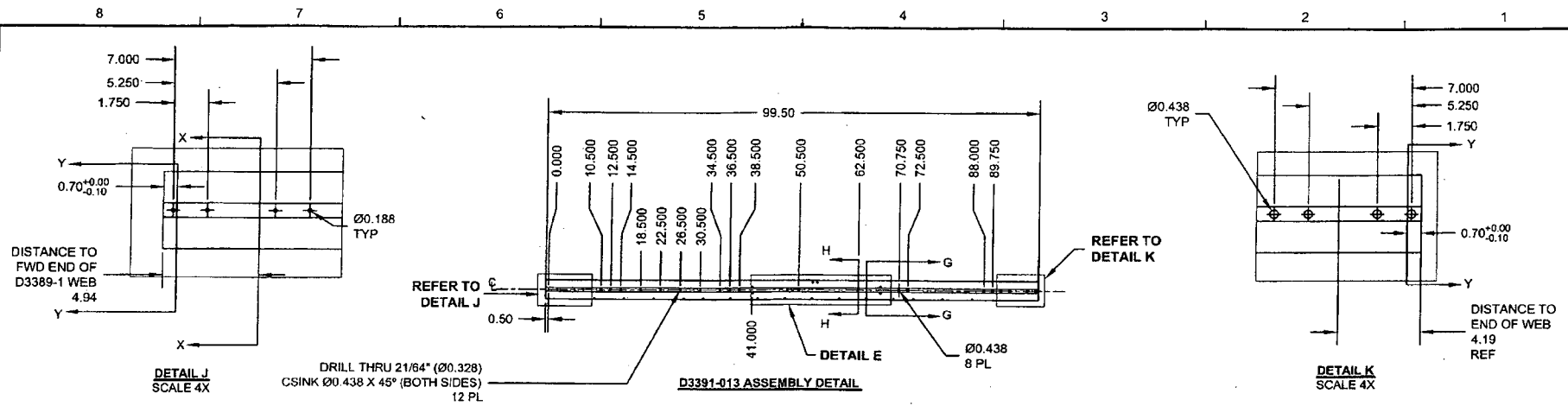
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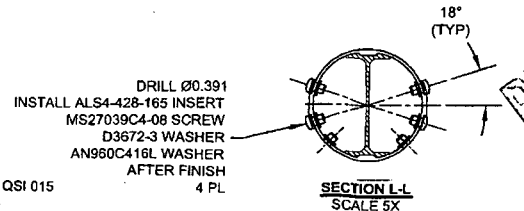
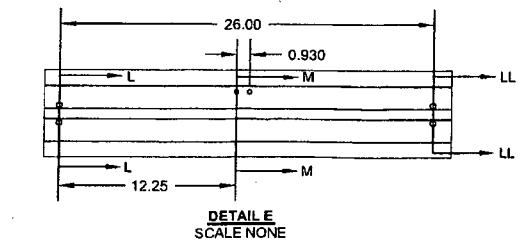
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**D3391-013 MID TUBE ASSEMBLY PARTS LIST**

QTY	PART NUMBER	DESCRIPTION
X	D3391-013	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
4	D3672-1	WASHER
4	D3672-3	WASHER
12	D3681-1	SPACER
24	AELS-1032-130	INSERT
4	ALS4-428-165	INSERT
4	AN960C10L	WASHER
4	AN960C416L	WASHER
4	MS27039C1-09	SCREW
4	MS27039C4-08	SCREW

- D3391-013 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
  - 3) WELDING: PER DART QSI 004



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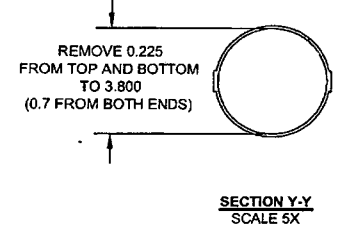
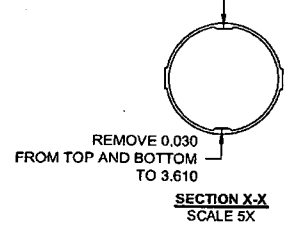
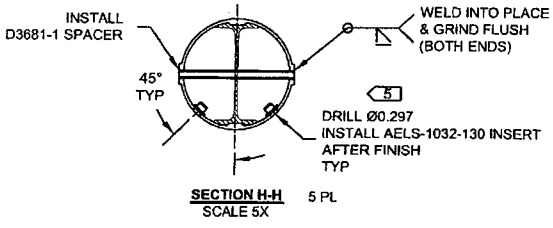
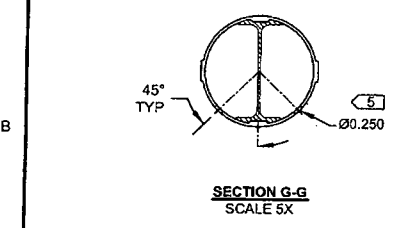
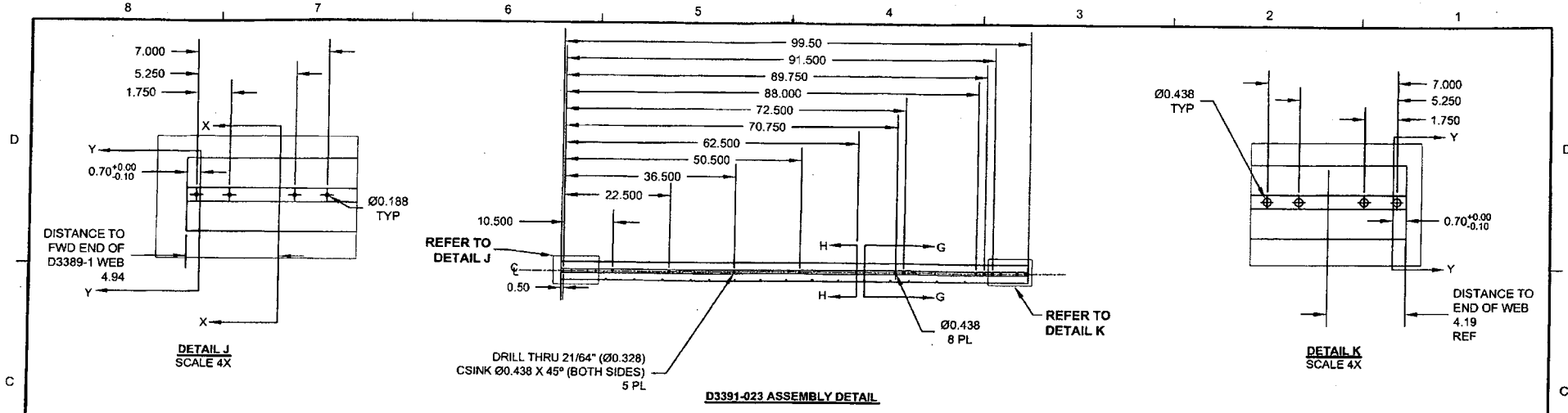
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY -	PART NUMBER	DESCRIPTION
023		
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

- D3391-023 MID TUBE ASSEMBLY**
- 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
  - 2) INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
  - 3) WELDING: PER DART QSI 004

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**VIEW BB-BB**  
SCALE 4X

**VIEW W-W**  
SCALE 4X

**SECTION AA-AA**  
SCALE 6X

**SECTION N-N**  
SCALE 6X

**SECTION P-P**  
SCALE 6X

**SECTION Q-Q**  
SCALE 6X

**SECTION R-R**  
SCALE 6X

**DETAIL S**  
SCALE 4X

**DETAIL V**  
SCALE 6X

**DETAIL W-W**  
SCALE 4X

**D3391-3 AFT DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

**412 FLOAT SKIDTUBE**

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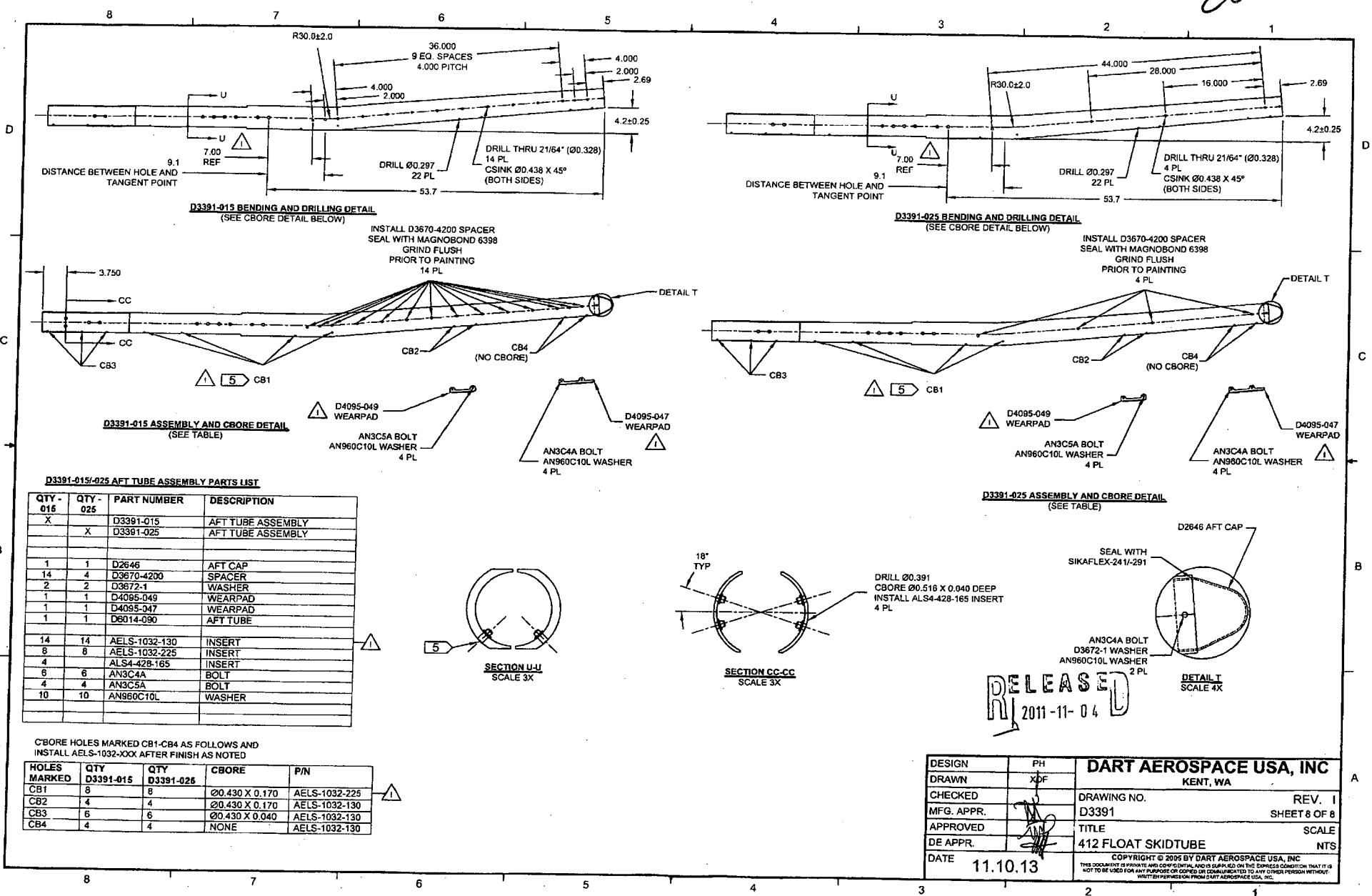
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**D3391-015/-025 AFT TUBE ASSEMBLY PARTS LIST**

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D2646	AFT CAP
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
1	1	D4095-049	WEARPAD
1	1	D4095-047	WEARPAD
1	1	D6014-090	AFT TUBE
14	14	AELS-1032-130	INSERT
8	8	AELS-1032-225	INSERT
4	4	ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER

CBORE HOLES MARKED CB1-CB4 AS FOLLOWS AND INSTALL AELS-1032-XXX AFTER FINISH AS NOTED

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	8	8	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries